

SHIP 25/01

Work Order ID 55350



January 13, 2010 12:34:59 PM

Item ID:	D3371-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pedal Lock Assembly					
Start Date:	1/13/10	Start Qty:	5.00		Cust Item ID:	
Required Date:	1/22/10	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3371	Rev B

100	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00
Powdercoat	Memo	0.00
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____	
	FINISH TIME: _____	

110	QC3- Inspect Part Finish	0.00
QC	Memo	0.00
Quality Control		

120	Small Fab	0.00
Small Fab	Memo	0.00
Small Fab		

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.; 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and

SAP 10-01-21

10/01/21

AKR

262 Locktite Batch: M109687

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55350

January 13, 2010 12:35:00 PM



Page 2

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 1/13/10 Start Qty: 5.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384. Identify as D3384-045

SAD 10-01-21

S

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. Identify as D3371-041 & attach keys. Record the Key Number on page 4

SAD 10-01-21

S

Key # 6420A x 5

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 10/01/21

(45)

Pho ⇒

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041 PAR #: N/A Fault Category: MACHINE NCR: Yes No DQA: 1 Date: 10.01.22
 Resolution: acceptable Disposition: use as is QA: N/C Closed: 10/01/26

NCR: 55350		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/21	18	Found @ inspection that the hole for the 1/4"-20 bolt is not as per spec to Dwg. R.C. D3371-3 B2-51400	10.01.21	Part is acceptable. Does not effect function at installation	SAD 10-01-21	S 10/01/21		S 10/01/21
		was machine incorrectly. L.O.A when following the Dwg.		→ Record on employee's Job training for Prom w/o 51400 D3371-3				

NOTE: Date & initial all entries

Work Order ID 55350

January 13, 2010 12:35:00 PM



Page 3

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 1/13/10 Start Qty: 5.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 493

0.00



Packaging

Memo

0.00

Packaging

10-1-21

(3X) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/22

MF 10-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 13, 2010 12:34:57 PM

Page 1
3

Work Order ID: 55350

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly



Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Date: 1/13/10

Required Date: 1/22/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3371-1 		Manufactured	No			100	Each	0.0000	5.0000			
Pedal Lock Base												
D3371-3 		Manufactured	No			100	Each	6.0000	5.0000			
Pedal Lock Cover												

B 55349 8 10/10/20 (5)

P

Warehouse
Location

Main Warehouse

ST

22288

51400

Loc Qty

6

1

5

Loc Code

22288 1X
51400 4X

LU

HX-81



1/4"-20 SHCS 3/8" long

Purchased

No

100

Each

20.0000

5.0000



Warehouse
Location

Main Warehouse

ST

110383

Loc Qty

20

20

Loc Code

110383

P 10/1/20 (5)

AN526C832R6



Screw

Purchased

No

120

Each

440.0000

20.0000



Warehouse
Location

Main Warehouse

ST

16612

Loc Qty

440

440

Loc Code

16612

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 13, 2010 12:34:57 PM

Page 2

Work Order ID: 55350

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly




Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Date: 1/13/10

Required Date: 1/22/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2728-7 		Manufactured	No			120	Each	0.0000	0.0000			
Dart Logo Label D3373-7 KA 		Manufactured	No			120	Each	0.0000	5.0000			
Cam Lock 238-028 		Purchased	No			130	Each	114.0000	10.0000			
3/16" Dowel Pin .5" long												

B22554



SAD

10-01-21

B22640



[Handwritten signature]

[Handwritten signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

114

106673

85

17278

29

17278

CBL-460



Purchased

No

130

Each

296.0000

10.0000



[Handwritten signature] 01/13/10 (5)

Loop Sleeve

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

296

111342

110

113002

186

111342

January 13, 2010 12:34:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 12:34:58 PM

Page 3

Work Order ID: 55350

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly


Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Date: 1/13/10

Required Date: 1/22/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3384-1  Cyclic Sock		Manufactured	No			130	Each	6.0000	5.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

6

53632

6

AN960-416

Purchased

No

140

Each

154.0000

10.0000

53632

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

154

111808

121

19356

7

5519

26

CBL-1240

Purchased

No

140

Each

549.3478

8.7716

111808

Cable

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

549.3477737

107234

49.3477737

113565

500

107234

January 13, 2010 12:34:58 PM

Shop Packet Print

Page 3

PTO →

W/O: 55350		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.0.20		odd A3385-3 Hinge Batch: B22387 perm. change	SAD	10-01-20	5	W	C 10/01/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

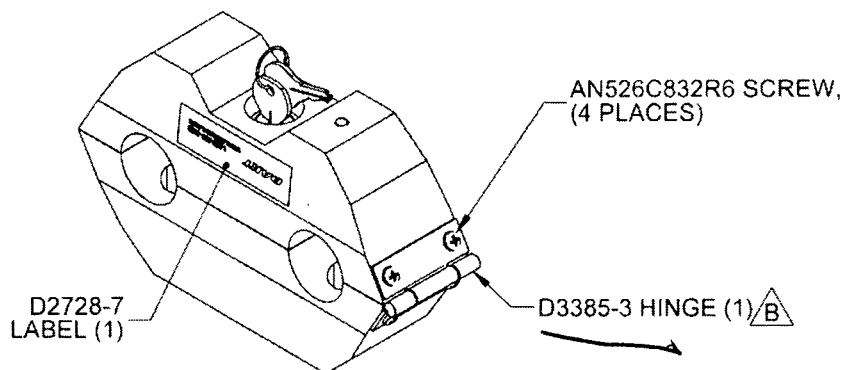
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

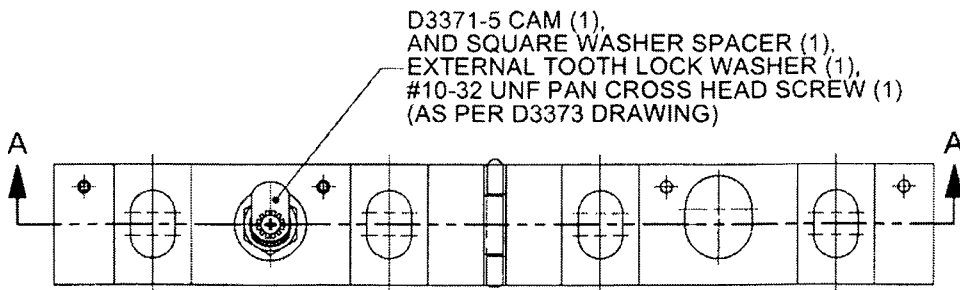
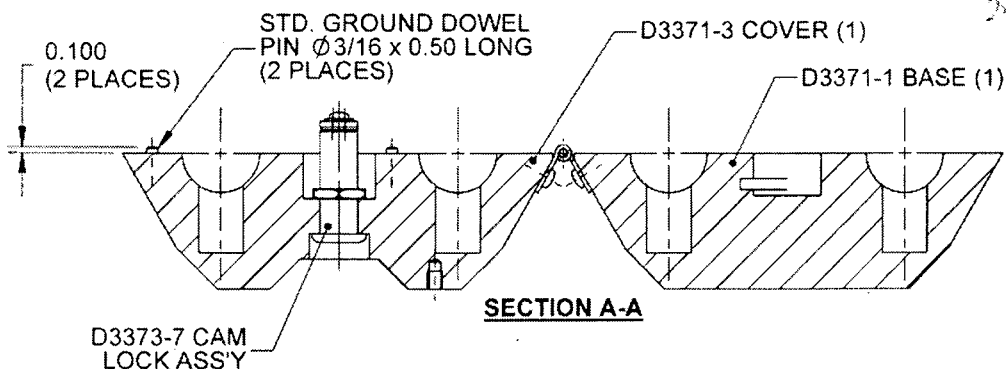
NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

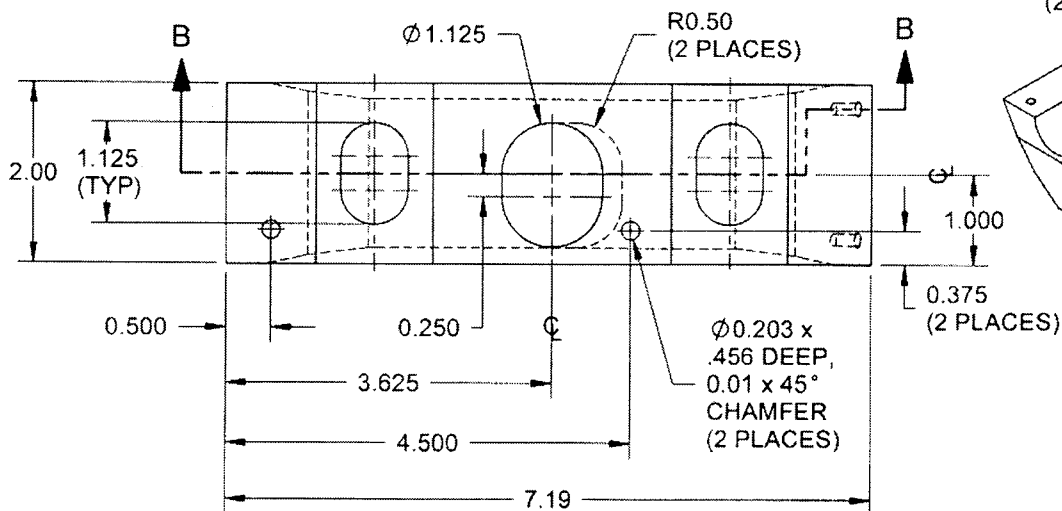
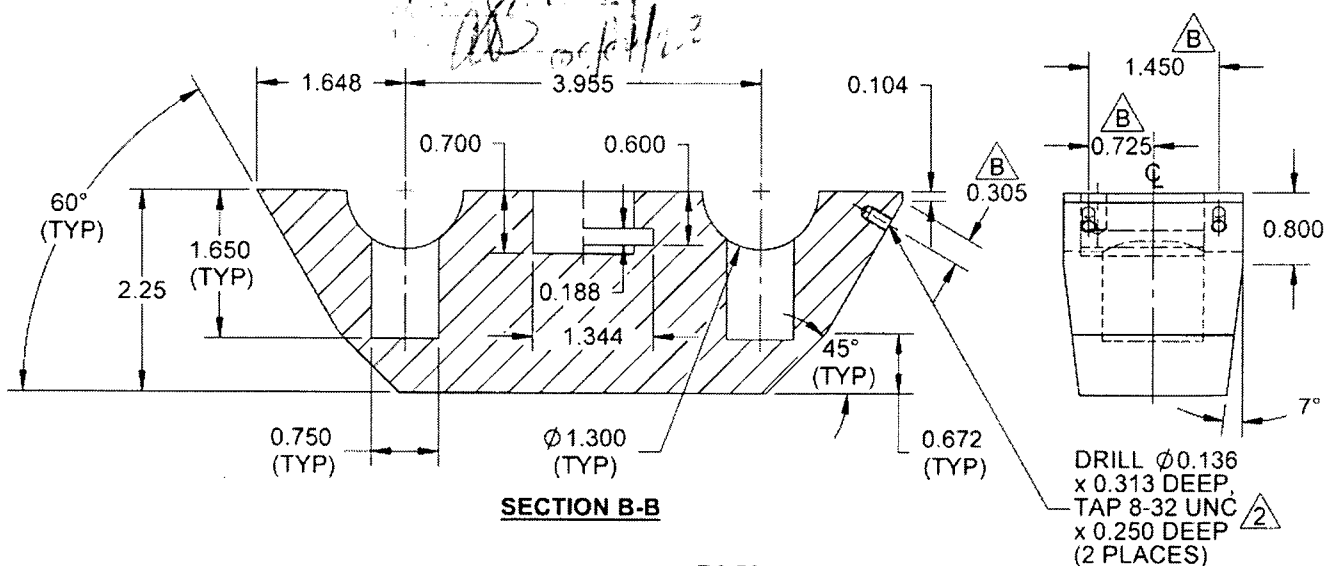
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



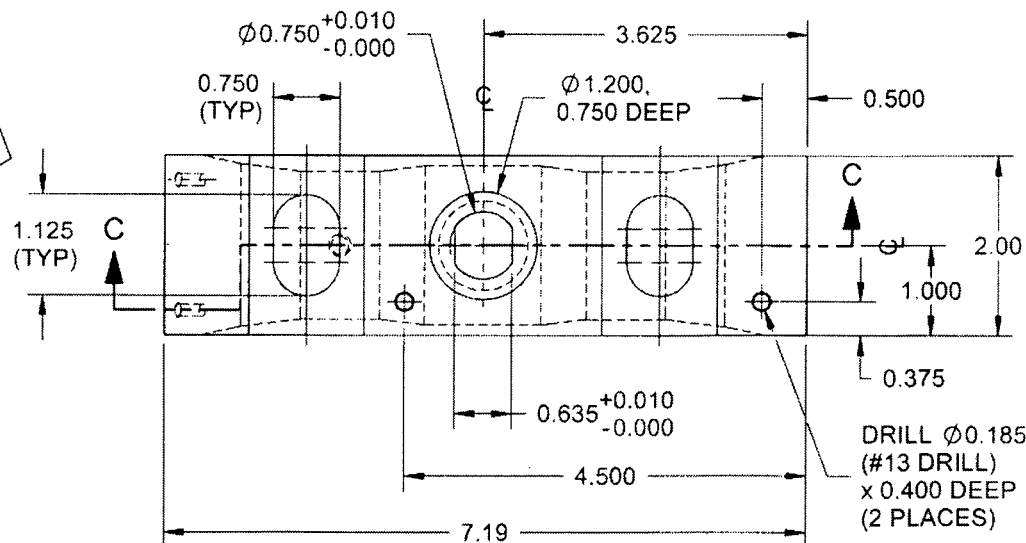
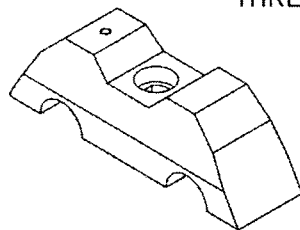
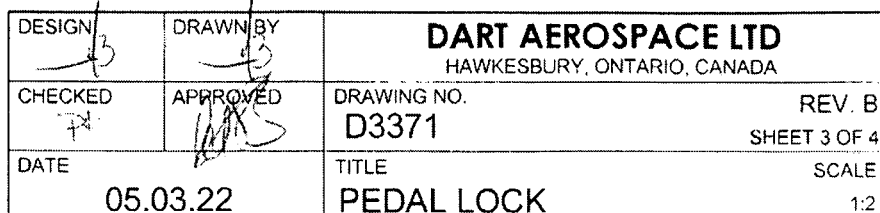
D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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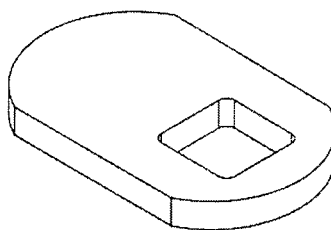
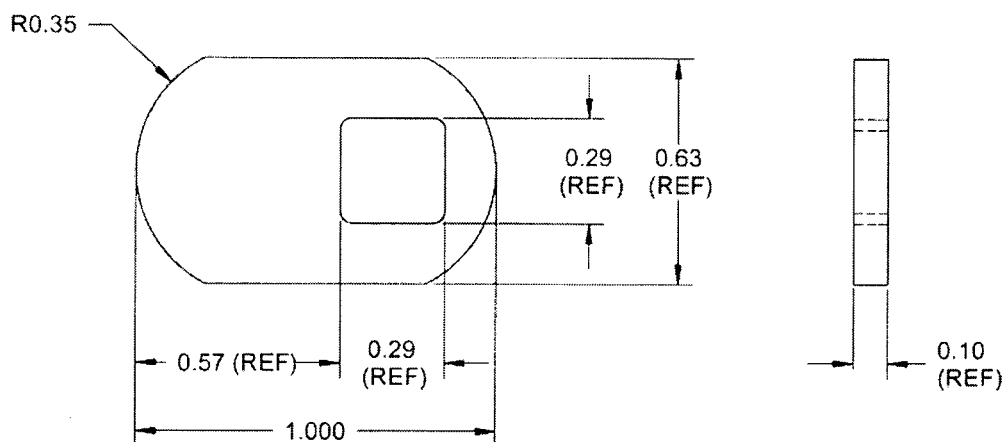
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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